

Date: Wednesday, 13/08/2008 10:54:59 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CONTOURED DETENT CLIP BASE	
<b>Job Number</b> :	41203	<b>Part Number</b> :	D34405	
<b>Estimate Number</b> :	11292	<b>Drawing Number</b> :	D3440 REV A	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	13/08/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	A	
<b>First Issue</b> :	11	<b>Type</b> :	MACHINED PARTS	
<b>Previous Run</b> :		<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	15/09/2008	<b>Qty:</b> 3 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	JLP 08.8.13			
<b>Comment</b> :	Est. A 05.06.30 New issue KJ/JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0250X01250	6061-T6 Bar .250 X 1.25
-----	--------------------	-------------------------



cut for remove note



**Comment:** Qty.: 0.1860 f(s)/Unit Total: 0.7438 f(s)  
 6061-T6 Bar .25" X 1.25" 1.25 X 1.25  
 Material: 6061-T6 Bar 1.250" x 1.250" (M6061T6B1.250x01.250)  
 Identify for D3440-5  
 Batch: M107744

mk 08/08/21

(8)

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW  
 Cut blank: 1.250" x 1.250" x 2.000" long

mk 08/08/21

(8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA536 and Dwg D3440 Dwg Rev: A  
 Identify as D3440-5 Folio Rev: AA  
 Deburr

JLP/J.L 08/08/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/08/23

5.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

L.S 08/08/23

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 13/08/2008 10:54:59 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONTOURED DETENT CLIP BASE

Job Number: 41203

Part Number: D34405

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



scf

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 93

8/8/25

8X

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/08/25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

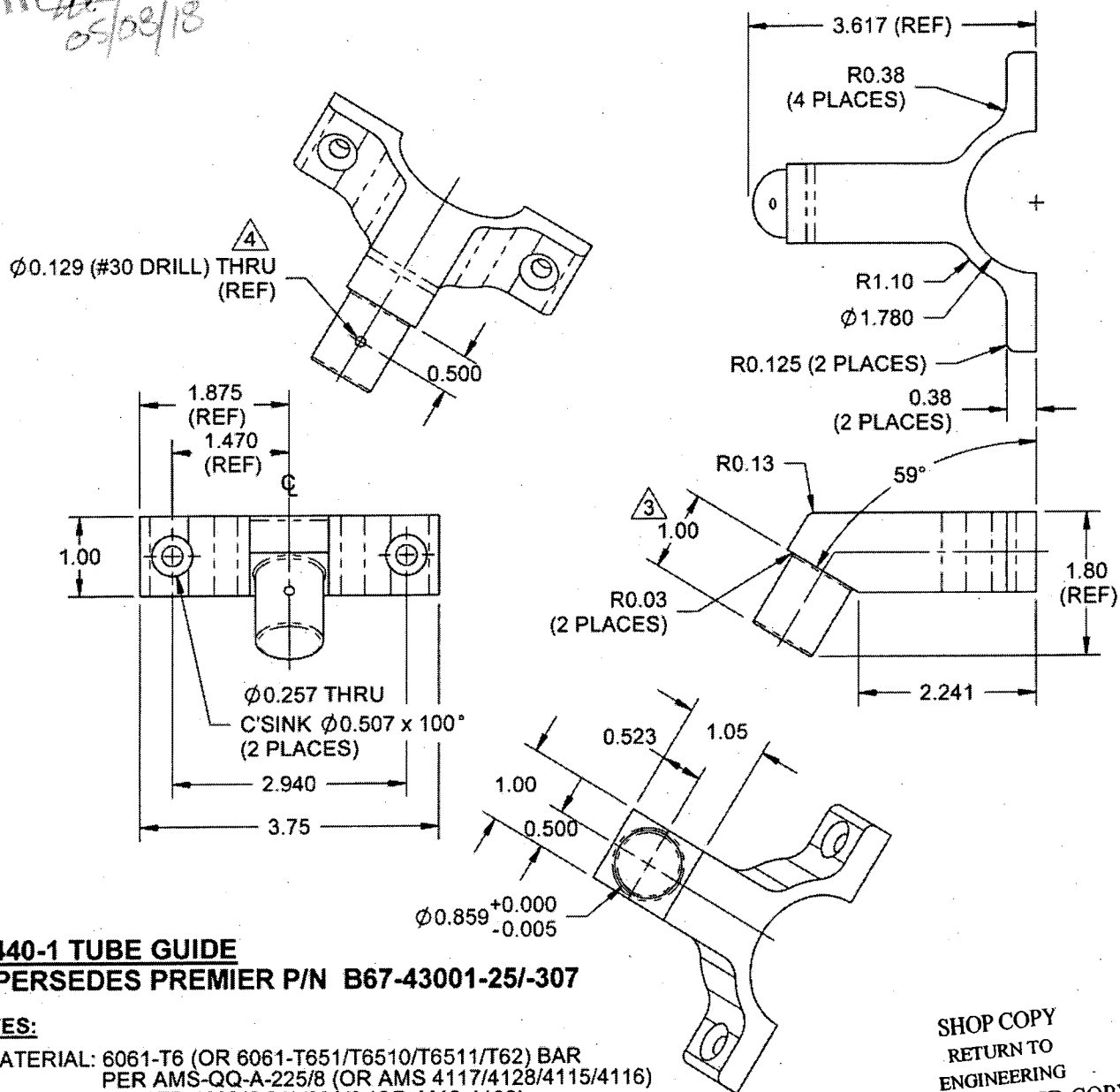
**NOTE:** Date & initial all entries



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05/08/18

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3440</b>	REV. A SHEET 1 OF 7
DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2
A	05.06.02	NEW ISSUE	

**D3440-1 TUBE GUIDE****SUPERSEDES PREMIER P/N B67-43001-25/-307****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/PP/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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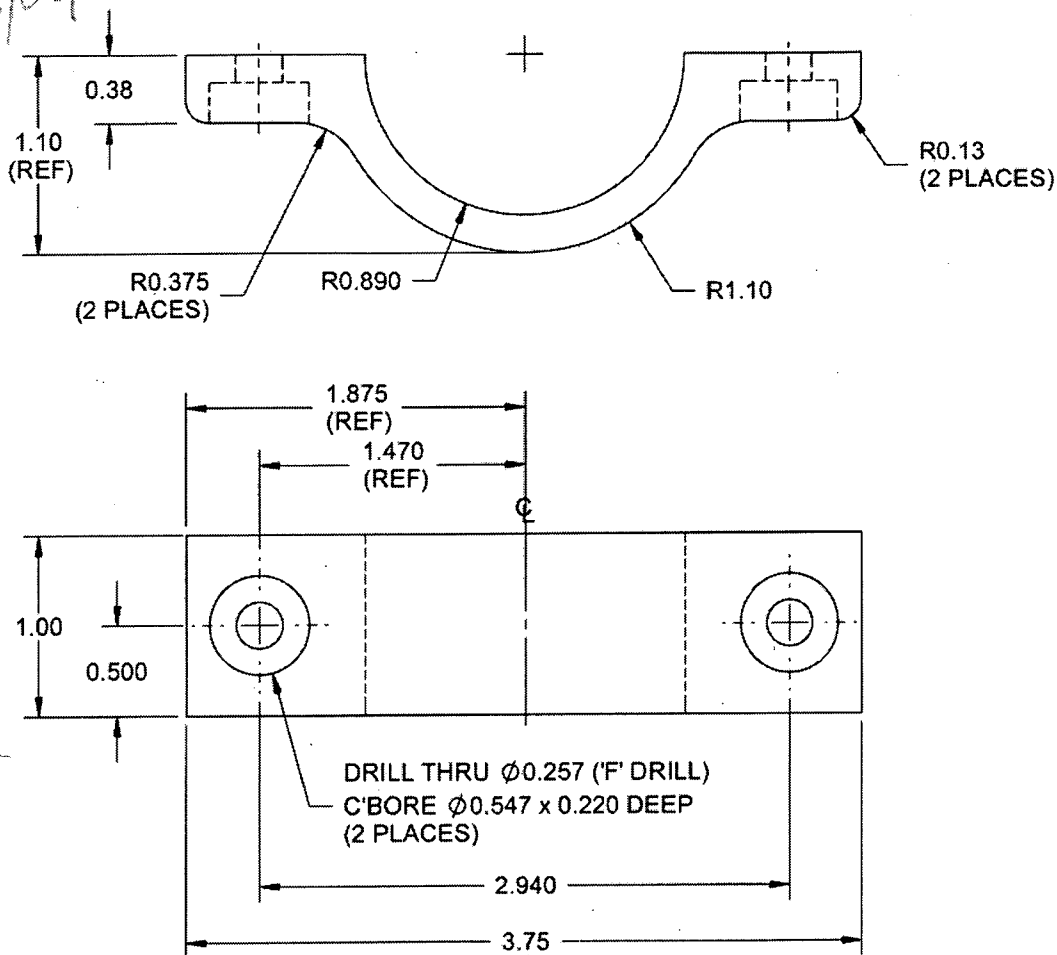
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

RELEASED  
05/08/18



### **D3440-3 CLAMP**

**SUPERSEDES PREMIER P/N B67-43001-309**

#### **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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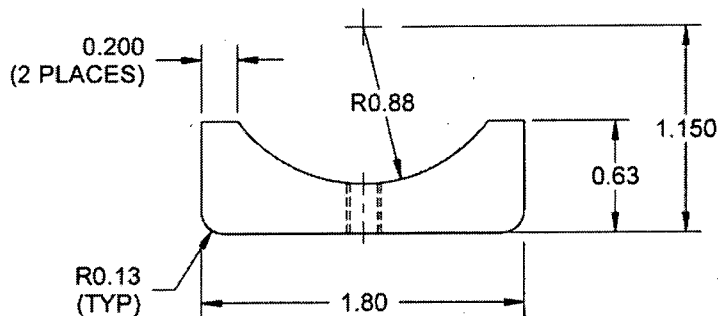
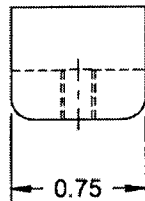
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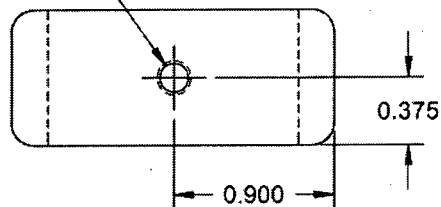
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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05/08/18



DRILL  $\varnothing 0.159$  THRU,  
TAP #10-32 UNF THRU



**D3440-5 CONTOURED DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-217**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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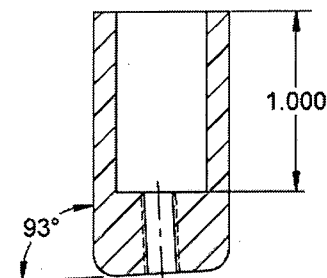
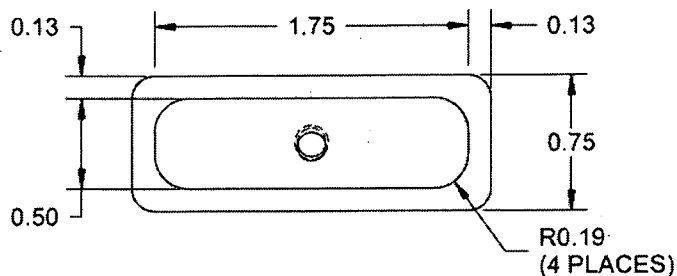
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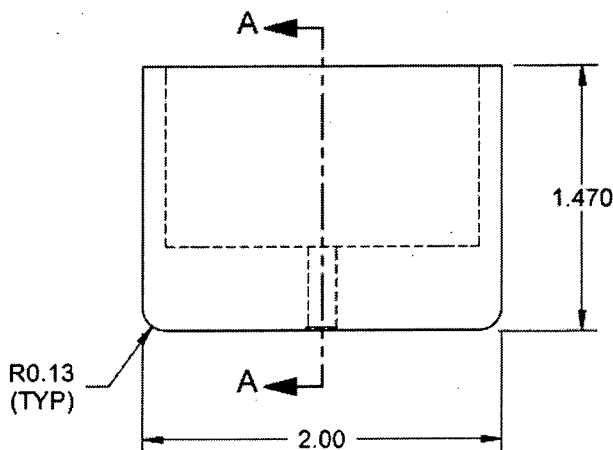
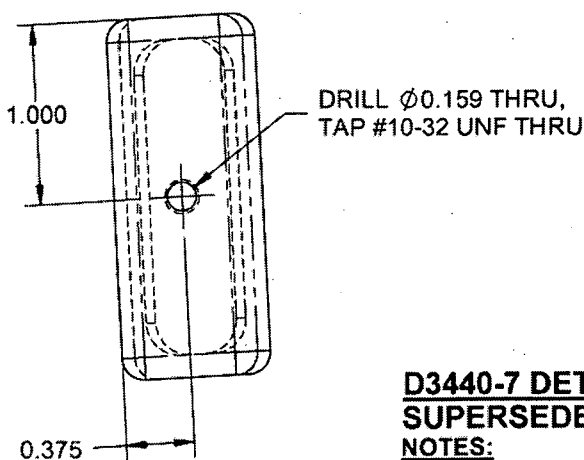
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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SECTION A-A



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**D3440-7 DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-221**

**NOTES:**

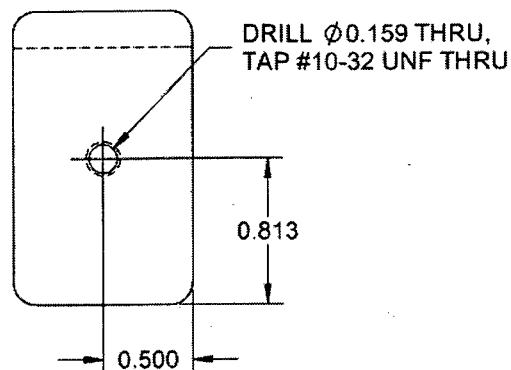
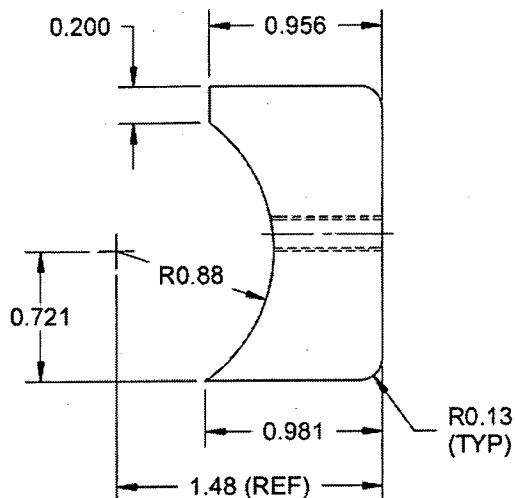
- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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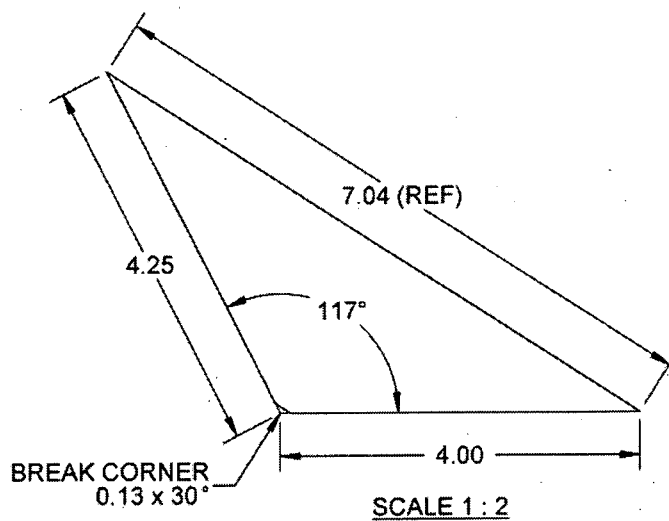
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DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS-QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

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*[Signature]*  
05/08/18



**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

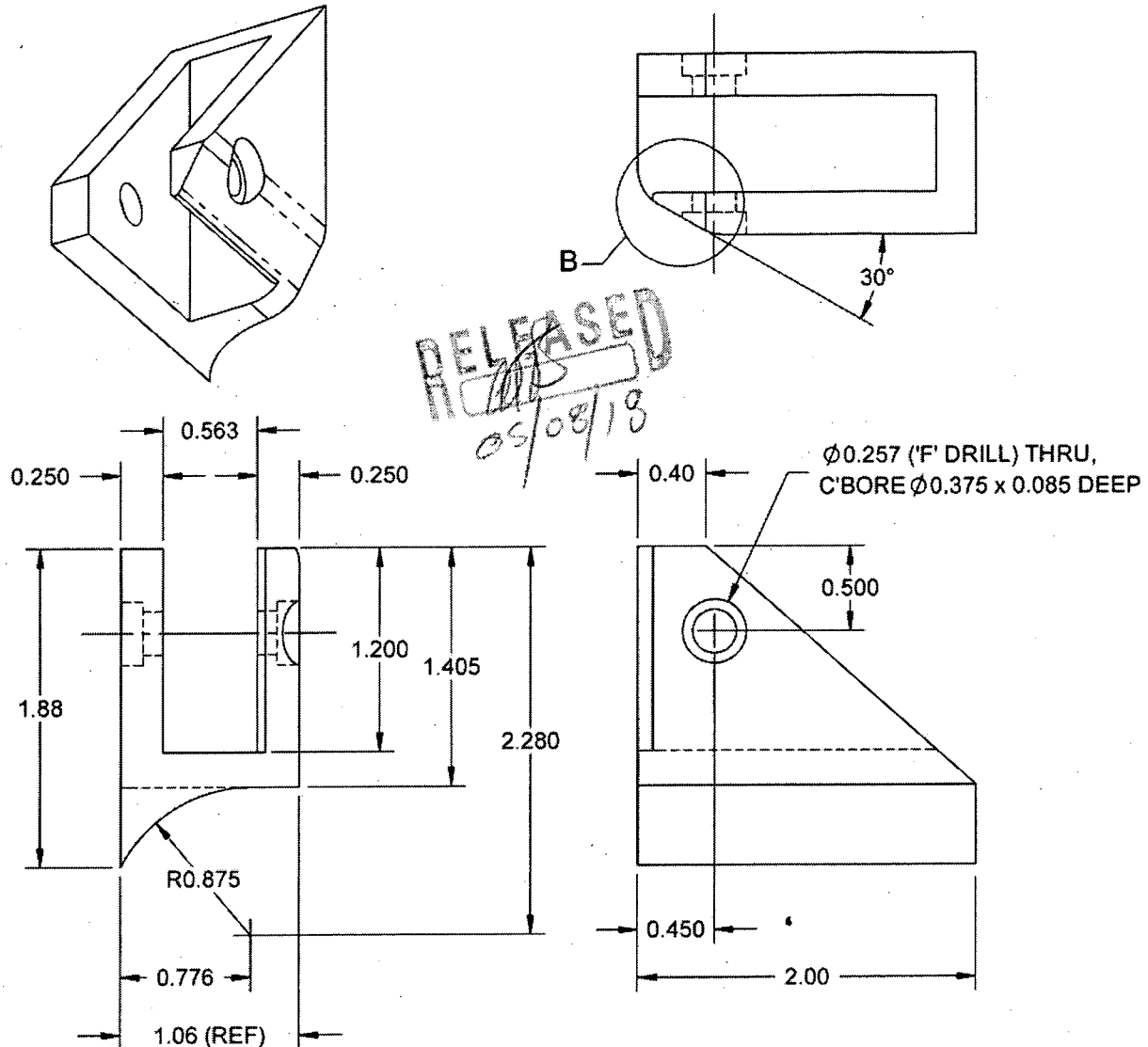
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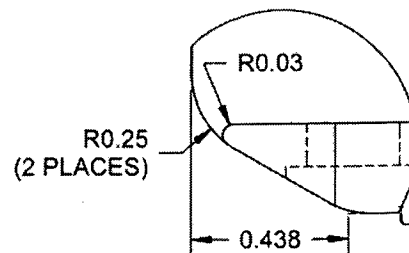
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-13 BRACKET**  
**SUPERSEDES PREMIER P/N B67-43001-273**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL B  
SCALE 2 : 1

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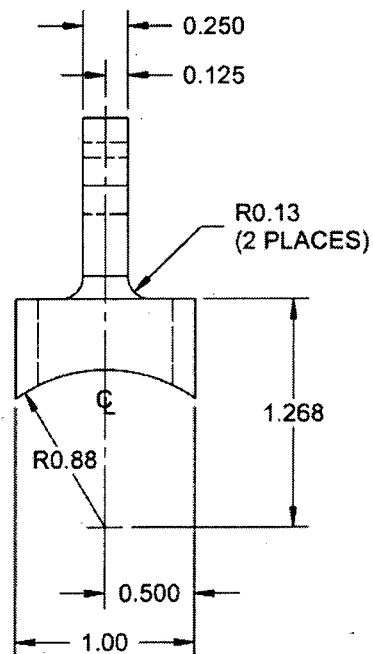
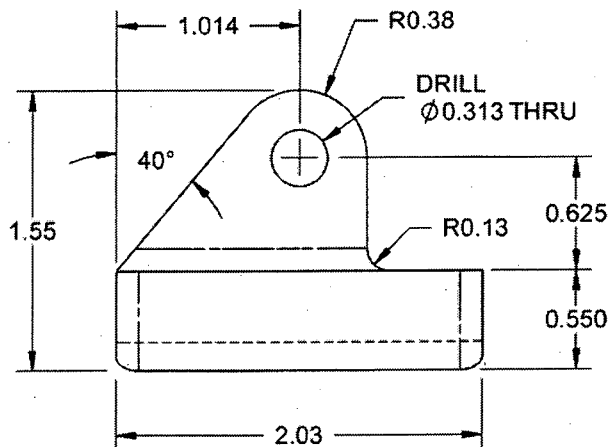
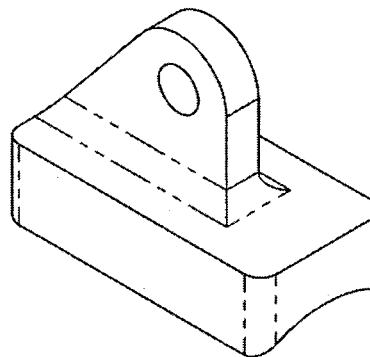
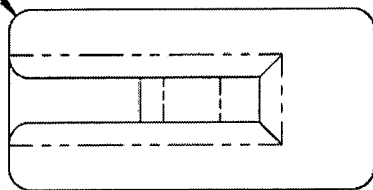
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DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:1

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*[Signature]*  
05/08/08

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE**  
**SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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